

Date: Tuesday, 19/08/2008 4:04:11 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 41435	
Estimate Number : 10312	
P.O. Number :	Part Number : D2646
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 37755	Material :
Written By :	Due Date : 20/09/2008 Qty: 50 Um: Each
Checked & Approved By : <u>NO 08.8.19</u>	
Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM	
Est Rev:H Changed Inserts 07-02-19 JLM	
est rev I changed inserts 07.06.11 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7000
1-Spin as per Dwg D2646
2-Material release note required

02/08/21 (50)

2.0	D2646P	Aft Cap
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Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
Ensure Material Release Note is attached

02/08/21 (50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D2646

02/08/28 (50) counters

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

02/08/28 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:11 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 41435

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/02 (50)

08/08/03 (50)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M

08-09-03 X50

8.0

POWDER COATING

POWDER COATING



M108523



(50X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320 OF
2:15

M-H 08/09/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

G.M 08.09.13 (50)

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch:

M105819

M-H

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-H 08/09/13

(50X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0809.15 (50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 41435

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



50x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-7

mf

08/09/15

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

五洲大藥房

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Sieg Manufacturing Ltd.

Turning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Aug. 27/08
Customer: Dart Aerospace
Packing Slip: 35672

Part#	Qty	Material	Check holes	Debur edges	Insp. By
B41435 rev. C	100	14G 1100	N/A	✓	<i>[Signature]</i>

Notes:

08/27/08

Material Certification Attached: Yes.

W. H. KERRY



ALCOA INTEL PRODUCTS
1480 Manheim Pike
Cancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 3009675396
DATE 4/23/2007
SKID NO 661032
SKID WGT 9.885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH
ITEM NO	1	PART NO				NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 114171 COIL: B01 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O
PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

0860028

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material meet the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

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